

Work Order ID 86962

July-10-12 9:08:19 AM

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slp 23/10

86962

Item ID: D2207-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Housing Weldment
 Start Date: 7/10/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2207	Rev C								

100 Large Fab 0.00
 100 Large Fab Memo 0.00
 Large Fab 1-Chamfer D2208 and D2207 before welding 2-Weld as per dwg D22073- Grind welds flush as per Dwg D2207
 (3) 12-10-18

110 QC10- Inspect visual per QSI004- ground welds 0.00
 110 QC Memo 0.00
 Quality Control
 (3) 12-10-19 DAS 09 2009

120 QC5- Inspect part completeness to step on W/O 0.00
 120 QC Memo 0.00
 Quality Control
 3 Smb 12/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Drill holes using DT8557 as per Dwg D2207								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

③ ④ 12-10-18

Smb
12-10-22

3

3 26 12-10-22

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>ST</u> 477 Memo	0.00 0.00							
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

9

12/10/23 (3)

ML5 12-10-23

MF 12-10-23

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Picklist Print

July-10-12 9:08:19 AM

Page 1

Work Order ID: 86962
Parent Item: D2207-041
Parent Item Name: Housing Weldment

Start Date: 7/10/12
Start Qty: 4.00

Required Date: 8/03/12
Required Qty: 4.00

Comments: IPP C 01.10.18 Added Step 10 and 11 SM
IPP D 07-10-11 REV C dwg DD verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-130 Insert		Purchased	No			100	Each	1,934.0000	4	16		BL 12-10-23	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST280		51							
				117717		27							
				118966		22							
				119775		2							
				ST282		1883							
				119530		73							
				120181		12							
				121444		1798							
D2207-1 Housing Body		Manufactured	No			180	Each	0.0000	1	4		EL 12-10-18	
D2208 Endcap, Torquemeter		Manufactured	No			100	Each	41.0000	2	8		EL 12-10-18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		40							
				84088		2							
				85855		10							
				85908		28							
				WA020		1							
				38144		1							

86826 x 3

12

2
4

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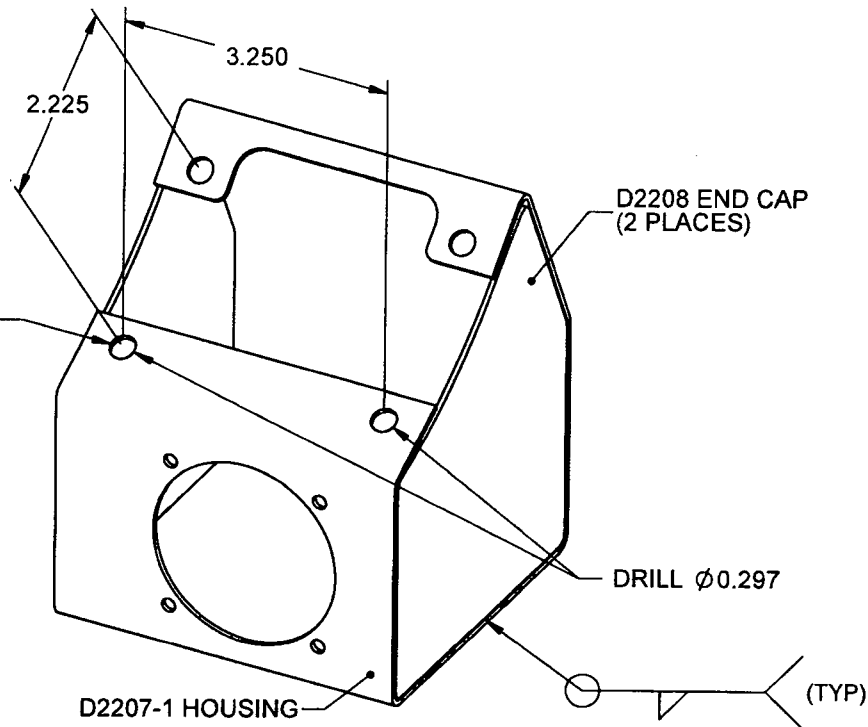
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AFTER FINISH, INSTALL
AKS7-1032-130 OR
ALS7-1032-130 OR
AKS4-1032-130 OR
ALS4-1032-130
(4 PLACES)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 86962 MCS
12/07/10



RELEASED

07-08-29

D2207-041 HOUSING ASSEMBLY

C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2207	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HOUSING	1:2
DATE	07.06.28	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

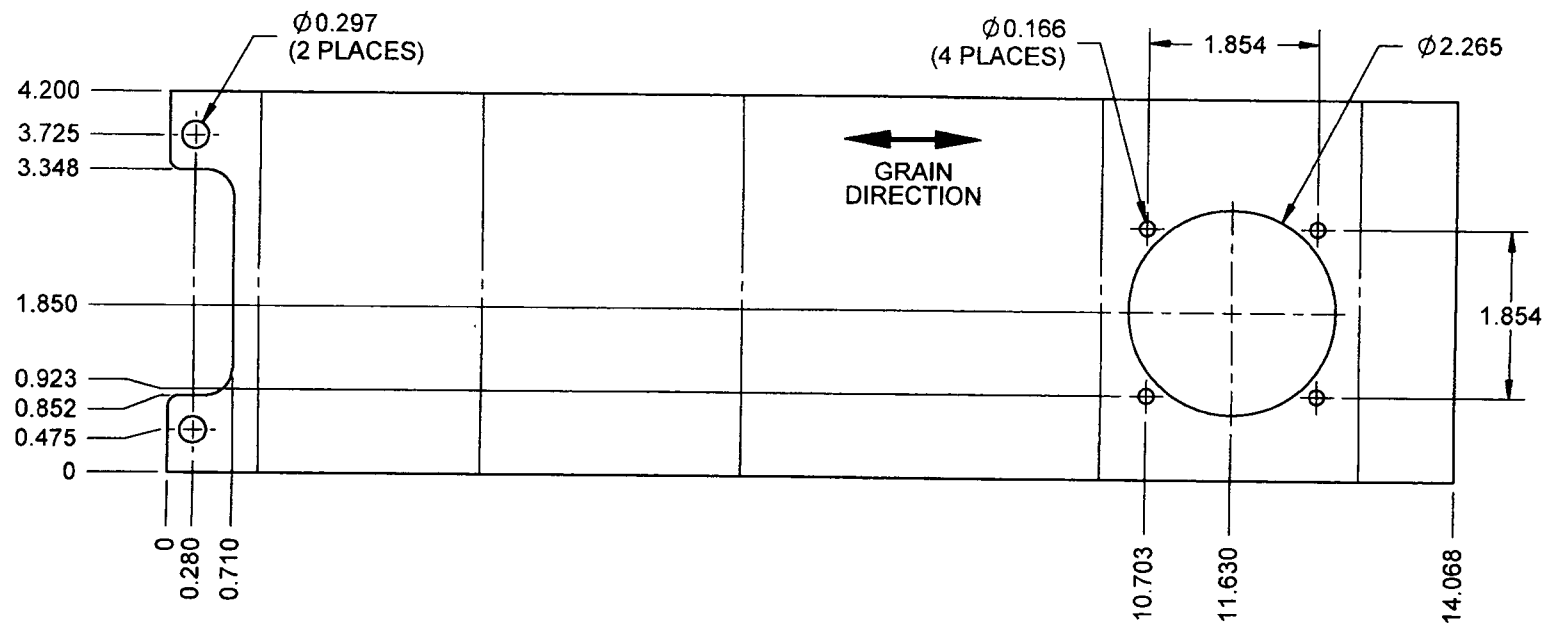
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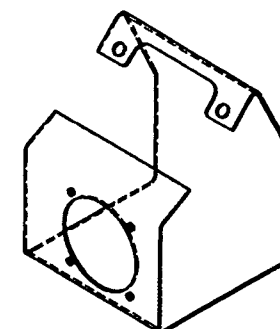
NOTE: Date & initial all entries



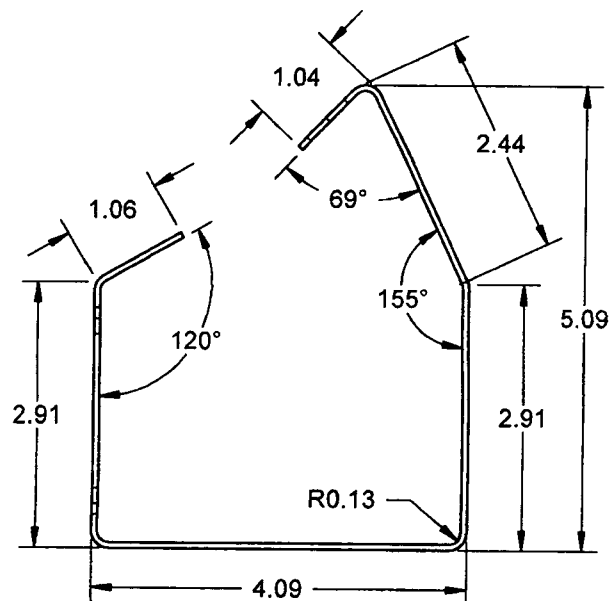
D2207-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



ISOMETRIC VIEW
(SCALE 1 : 4)



D2207-1 BENDING DETAIL

RELEASED

07.08.29

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2207	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HOUSING	1:2
DATE	07.06.28	COPYRIGHT © 1994 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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